

**CLAIMS**

1. A pouch comprising:
- a compartment;
- a multi-layer panel having an interior surface coextensive with the compartment and
- 5     an external surface; and
- a frangible piercing area disposed on the external surface, wherein the frangible piercing area is defined by a continuous arcuate channel created through at least one layer of the multi-layer panel.
2. The pouch of claim 1 wherein the channel defines the perimeter of a geometric shape.
- 10     3. The pouch of claim 2 wherein the shape is a circle.
4. The pouch of claim 2 wherein the shape is a teardrop.
5. The pouch of claim 2 wherein the shape is a U shape.
6. The pouch of claim 2 wherein the channel further comprises a hinge.
7. The pouch of claim 2 further comprising a first adhesive layer between the exterior
- 15     plastic layer and the interior metal foil layer.
8. The pouch of claim 2 further comprising a second continuous arcuate channel defined through at least one layer of the multi-layer panel.
9. A pouch, comprising:
- a compartment formed by an at least one multi-layer laminate panel that include an
- 20     exterior layer, wherein the laminate of the panel includes a frangible piercing point adapted to receive a straw, the frangible piercing point defined by a line of weakness that includes a hinge portion whereby when the frangible piercing point is pierced, the frangible piercing point remains coupled to the laminate material.
10. A container for juice, the container comprising:

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- a compartment formed by operably sealing a first panel, a second panel, and a third panel, the first, second, and third panel formed from a multi-layer metal foil laminate that includes an exterior layer, the compartment containing the juice; and
- a frangible piercing point adapted to receive a straw, the frangible piercing point
- 5 defined by a line of weakness including a hinge portion, whereby when the frangible piercing point is pierced, the line of weakness formed from a delaminated strip of the exterior portion of the multi-layer laminate material of the first panel.
11. A method of forming a pouch, the method comprising:
- supplying a flexible multi-layer sealable laminate material having an exterior layer;
- 10 applying laser energy to the exterior plastic layer in a strip to form a desired shape, the shape including one section that is not delaminated and wherein the shape defines a frangible piercing point;
- cutting the flexible multi-layer laminate material into panels; and
- forming the panels into a pouch, wherein the frangible piercing point is situated on an
- 15 exterior portion of the pouch in a desired position.
12. The pouch of claim 11 wherein the strip defines the perimeter of a geometric shape.
13. The pouch of claim 12 wherein the shape is a circle.
14. The pouch of claim 12 wherein the shape is a teardrop.
15. The pouch of claim 12 wherein the shape is a U shape.
- 20 16. The pouch of claim 12 wherein the strip further comprises a hinge.
17. The pouch of claim 12 further comprising a forming second continuous strip defined through at least one layer of the multi-layer panel.